

Date: Thursday, 2/23/2006 10:23:08 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RIGHT ARM WELDMENT
Job Number	: 25911		
Estimate Number	: 12281		
P.O. Number	: NIA	Part Number	: D3354042
This Issue	: 2/23/2006	S.O. No. :	NIA
Prsht Rev.	: NC	Drawing Number	: D3354 REV.A
First Issue	: NIA	Project Number	: N/A
Previous Run	: NIA	Drawing Revision	: A
	Type : LARGE FAB ASSY	Material	: NIA
Written By	:	Due Date	: 3/30/2006
Checked & Approved By	: <i>[Signature]</i> 06.02.23	Qty:	4 Um: Each
Comment	: est rev. A 06.02.09 new issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D33549	handle socket
-----	--------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty	part number	description	batch
1	D3354-9	Handle socket	B26769

CPL 06.06.23

(4)

2.0	D33541	inner shaft
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty	part number	description	batch
1	D3354-1	Inner shaft	B26360

CPL 06.06.01

3.0	D33547	left arm plate
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty	part number	description	batch
1	D3354-7	Left arm plate	B26768

CPL 06.06.01

(4)

4.0	D33543	shaft
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty	part number	description	batch
1	D3354-3	Shaft	B25596

CPL 06.06.01

(4)

CPL 06.06.01

4.1 TP-134 Pin

Batch: M16362

CPL 06.06.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 06/01/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:23:08 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 25911

Part Number: D3354042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg D3354

CPC

06-06-26

④

2-Grind welds flush as per dwg D3354

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06/06/26 4

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Mask areas indicated on dwg D3354

2-Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

DL 06/08/14 ④

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06/08/21 4

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 351

06/08/21 4

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.08.22

Job Completion



06/09/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

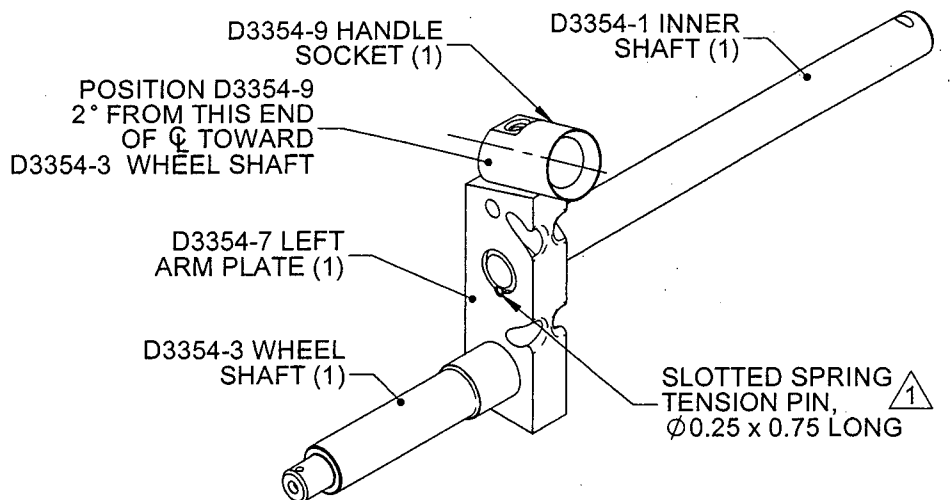
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

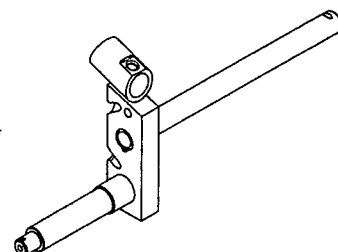
NOTE: Date & initial all entries

PRELIMINARY ISSUE

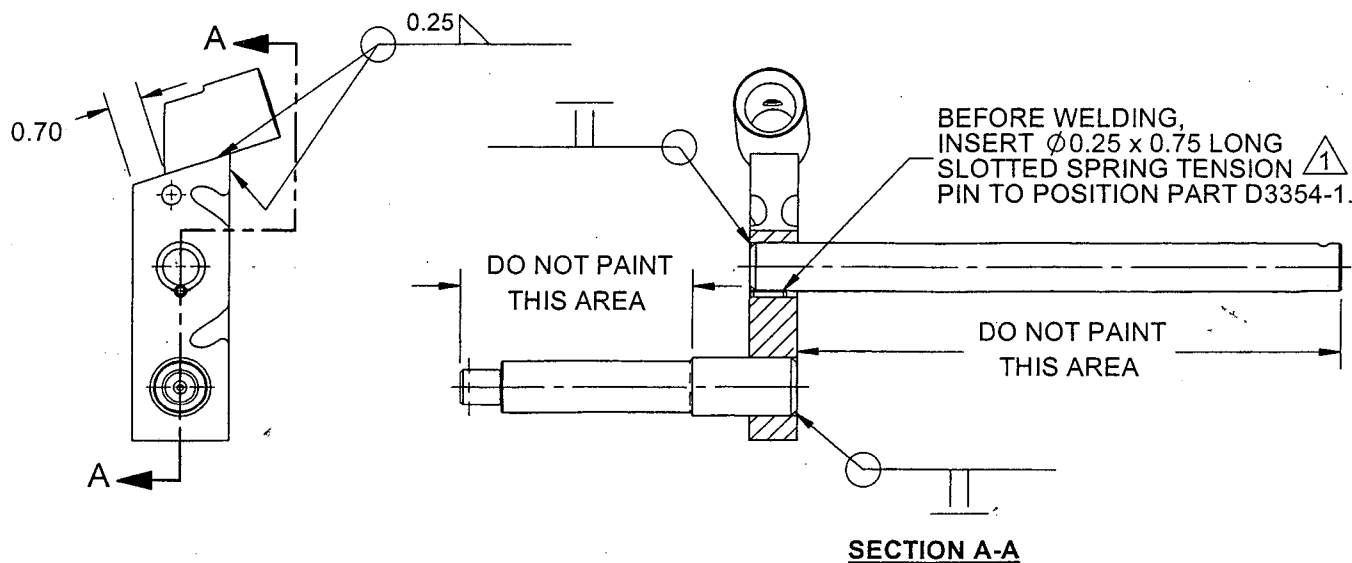
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CHECKED 13	APPROVED	DRAWING NO. <b>D3354</b>	REV. A SHEET 1 OF 7
DATE <b>04.12.13</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:4
A	04.12.13	NEW ISSUE	



**D3354-041 LEFT ARM WELDMENT**



**D3354-042 MIRROR ARM WELDMENT**



**NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 0054.8
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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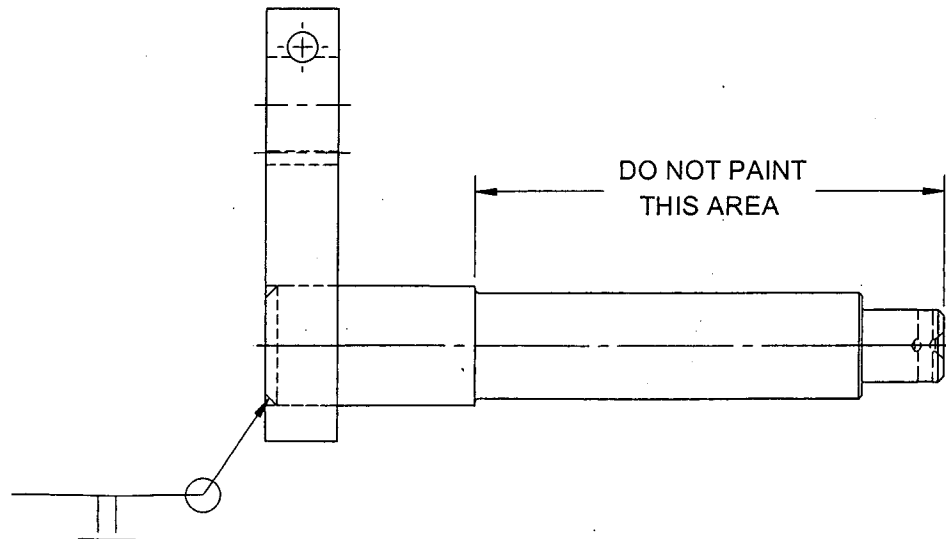
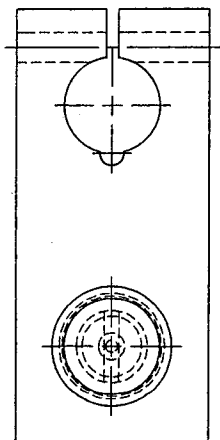
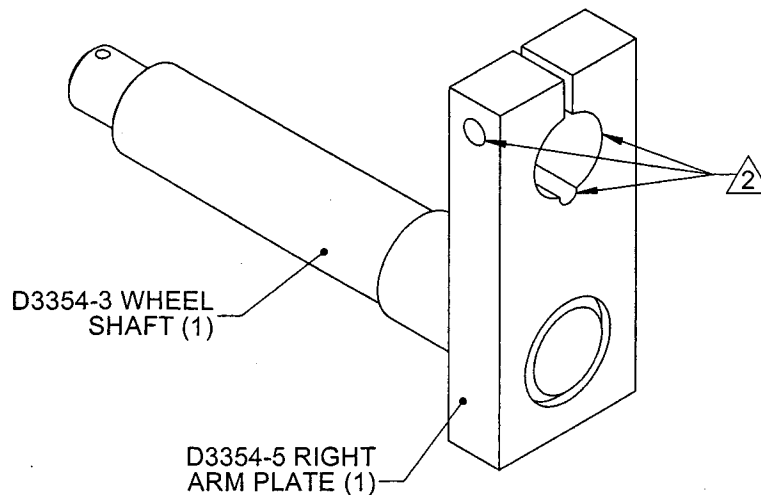
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:2



### D3354-043 RIGHT ARM WELDMENT

#### NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO AMENDMENT WITHOUT NOTICE
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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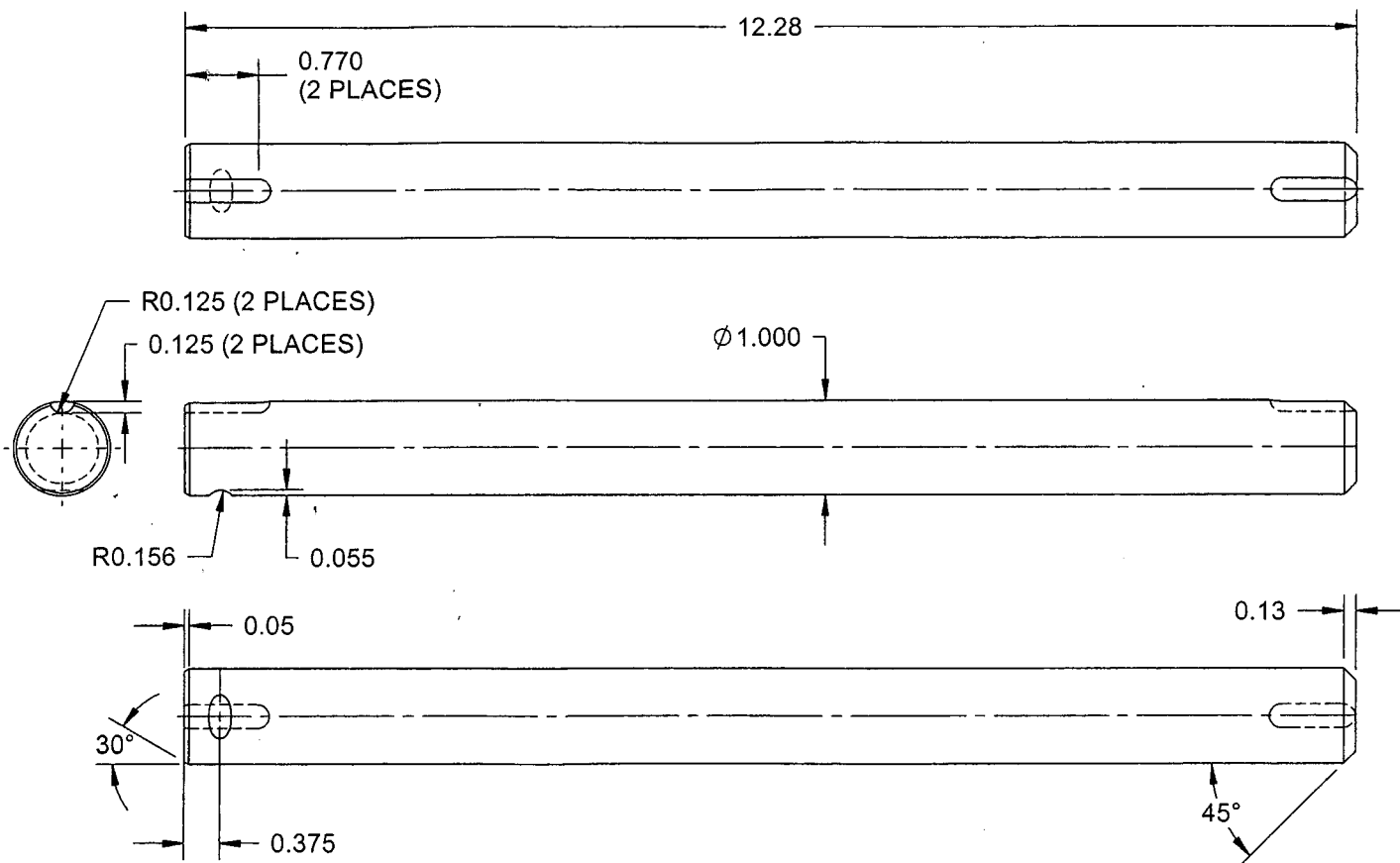
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DATE 04.12.13		TITLE LEFT ARM WELDMENT	SCALE 1:2



### D3354-1 INNER SHAFT

#### NOTES:

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR,  $\phi$ 1.250 (REF. DART SPEC. M4140-01)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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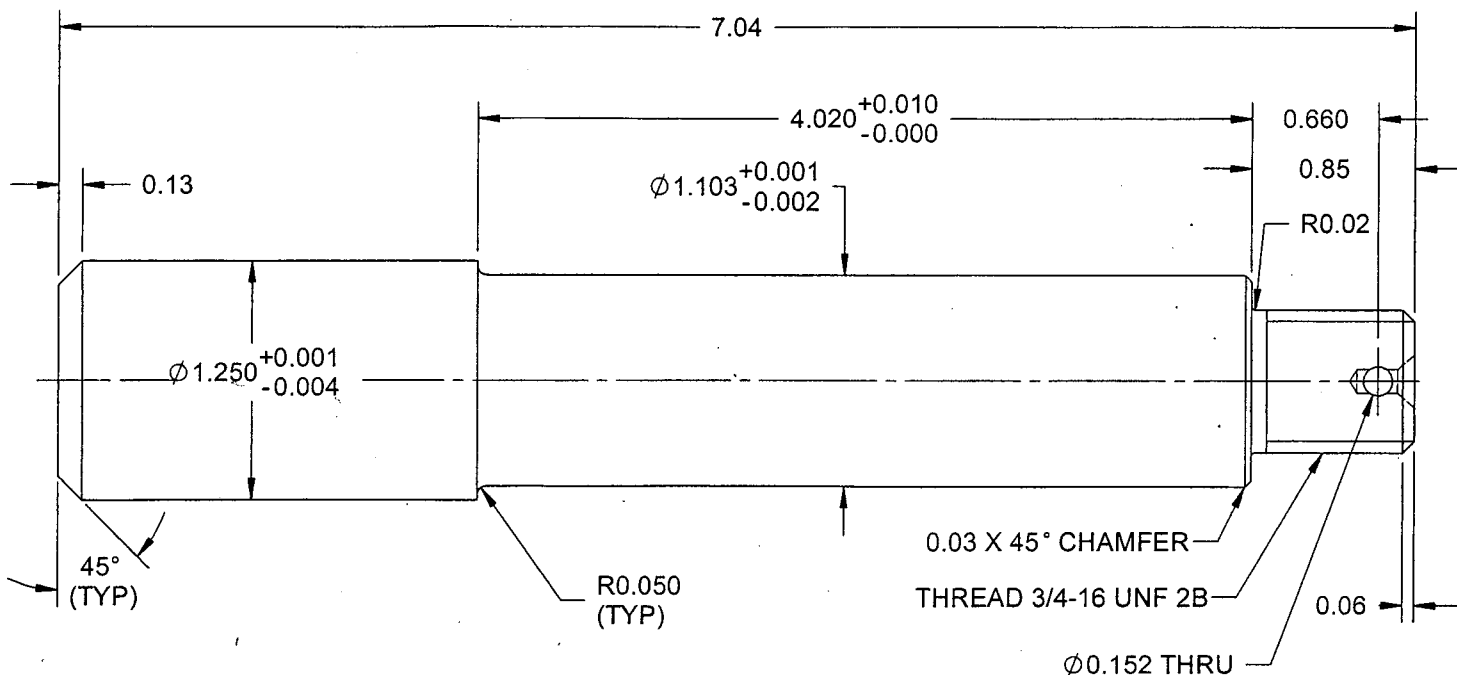
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DATE 04.12.13		TITLE LEFT ARM WELDMENT	SCALE 1:1



**D3354-3 WHEEL SHAFT**

**NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR,  $\phi 1.250$  (REF. DART SPEC. M4140H-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

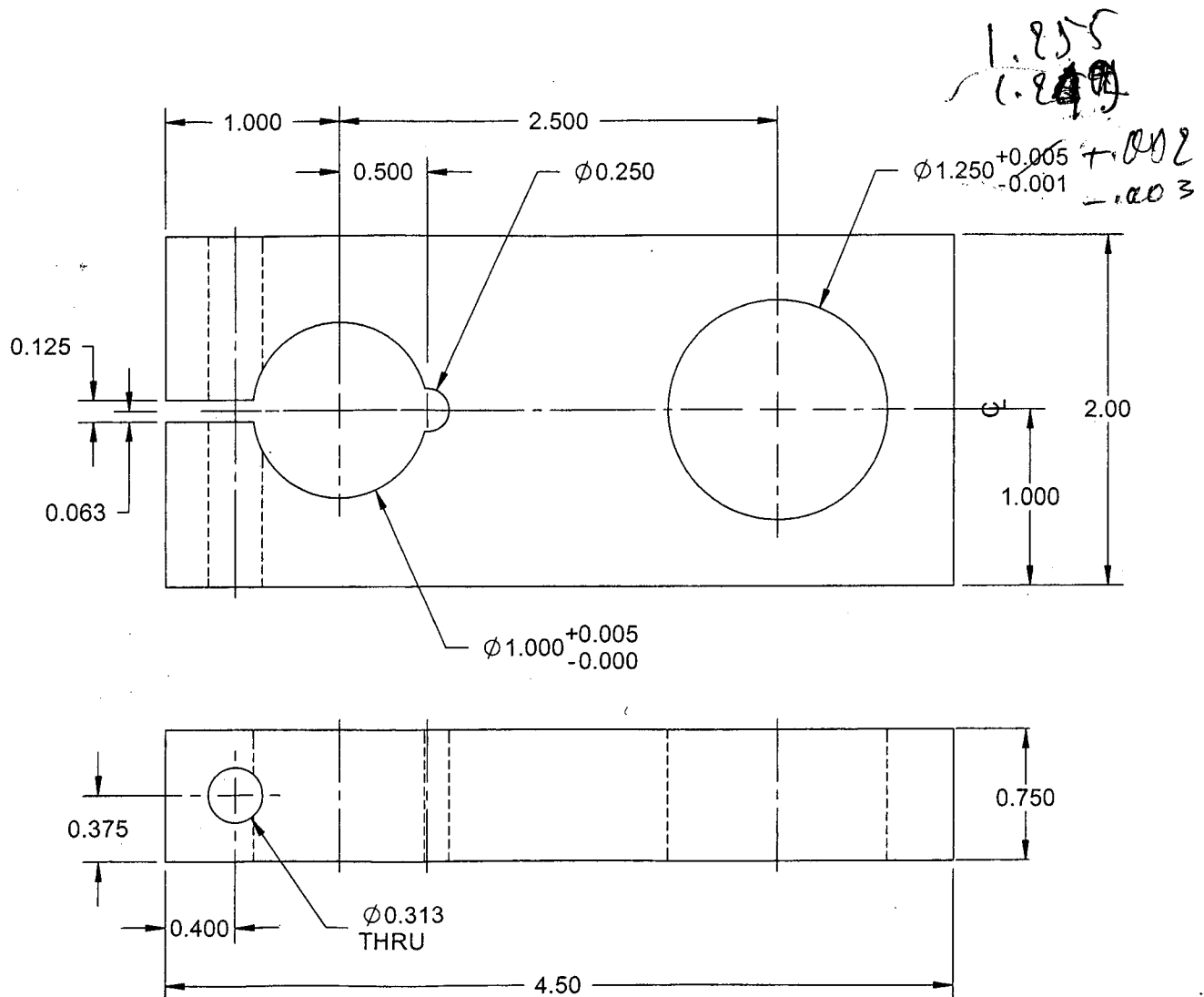
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:1



### D3354-5 RIGHT ARM PLATE

#### NOTES:

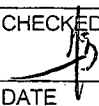
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

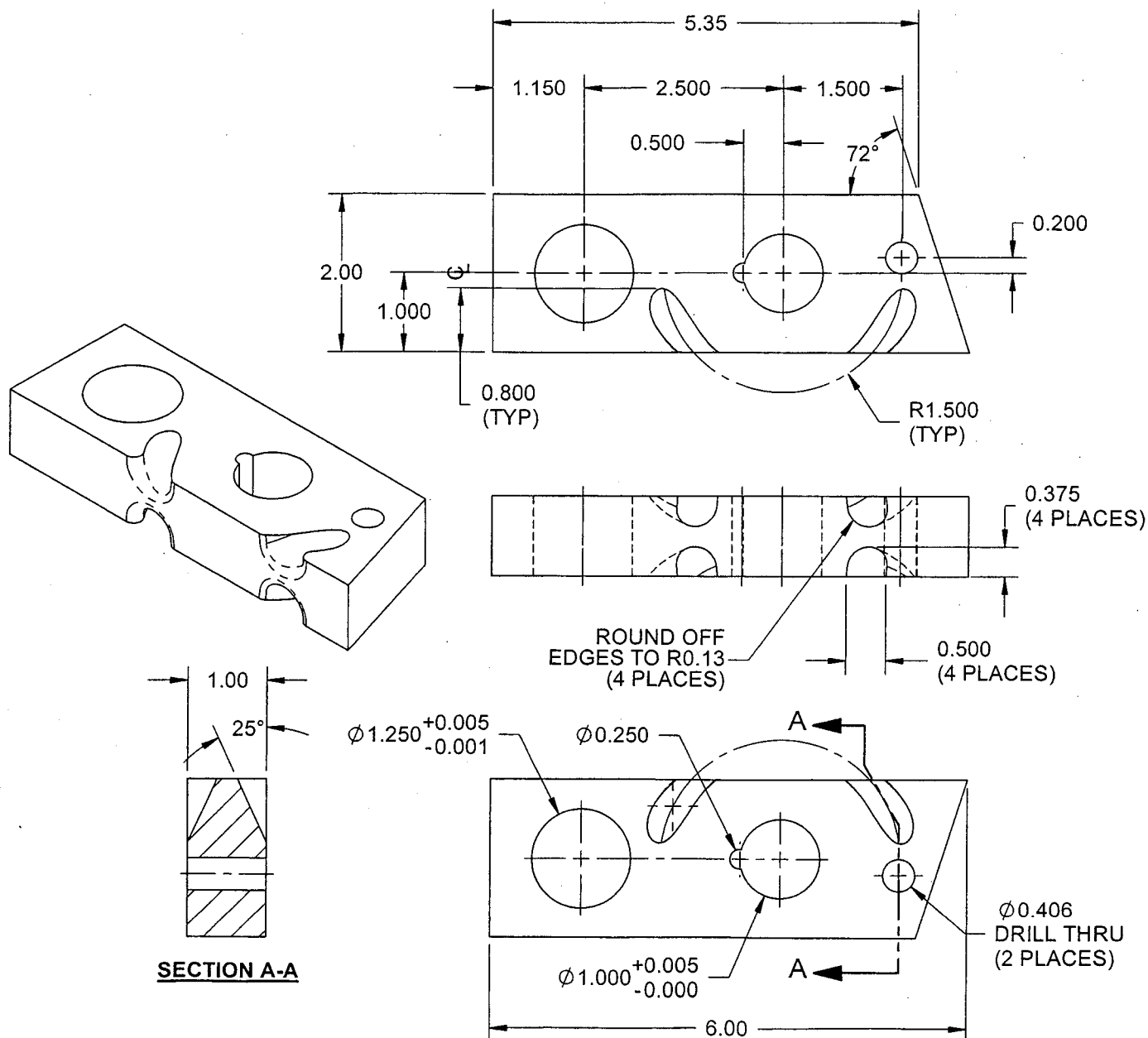
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:2



### D3354-7 LEFT ARM PLATE

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

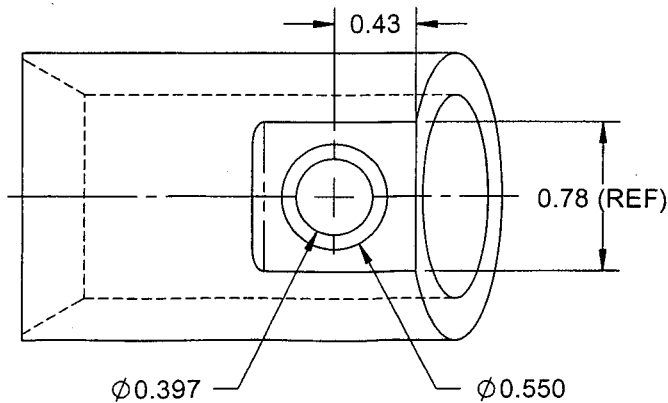
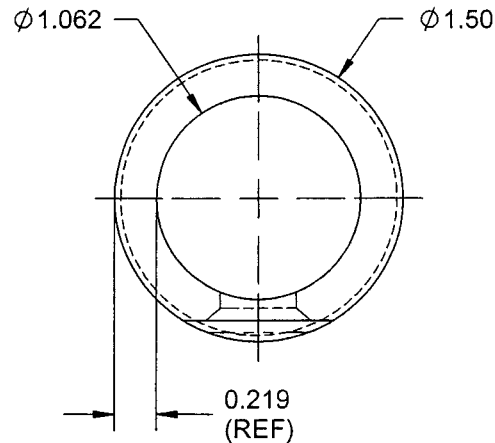
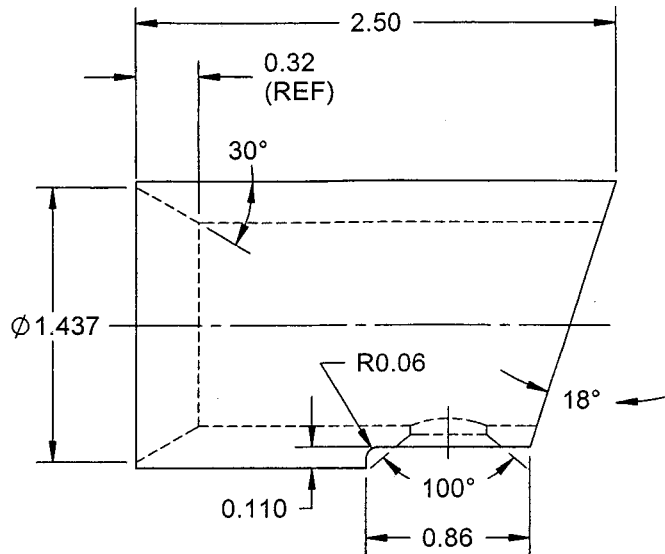
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DATE 04.12.13	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:1



### D3354-9 HANDLE SOCKET

#### NOTES:

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR  
ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077  
(REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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